Work Order ID 50227  July 14, 2009 10:26:01 AM										Pag		
Revision ID:	D2274 F Radius Block			Accept				S	Setup Star Stop			
	7/15/09	Start Qty: 148.00 Beq'd Qty: 148.00		1111   111   111 1111   111   111	Cust Item I Customer:							
Approvals:	Process Pla		Date:	Tooling:	Da	ate:		F	Run Star Stop			
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr D2274	Rev Rev	ision Nbr										
100 Shear	Rev	SHEÁR <b>Memo</b>	long +/- 0.030"[¬Not	0.00  0.00  e: 1 blank makes 9 pieces	m2 09/07/	bo			· · · · · · · · · · · · · · · · · · ·			
HAAS 1	machine #1	HAAS CNC VERTICAL  Memo  Machine as p	MACHINING #1 er folio D2274	0.00 0.00	R 09/07/20 3 09/07/21	) <sub>.</sub>		170	0			
120 		QC2- Inspect parts off ma	chine FAI/FAIB ·	0.00	Roglo7120							

Memo

Quality Control

## **Dart Aerospace Ltd**

		— <del></del>								
W/O:			WC	RK ORDER CHANG	ES			<del> </del>		
DATE	STEP	PRO	CEDURE CHAI	IGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				**						
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: `	Yes N	lo <b>DQ</b>	<b>A</b> :	_ Date: _	
	Re	esolution:	Disposition	i:	_ QA: N/	C Clo	sed:		Date: _	
NCR:		V	ORK ORDE	R NON-CONFORMA	NCE (I	NCR)				
DATE	STEP	Description of NC		Section B  Sign &			ation	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
		•		÷						
								=		
									W-20	

#### Work Order ID 50227

July 14, 2009 10:26:01 AM



Item ID:

D2274

Radius Block

F

**Revision ID:** Item Name:

**Start Date:** 

Required Date: 7/15/09

7/15/09

QC:

Start Qty: 148.00 Req'd Qty: 148.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan: \_\_\_\_

Date: Date:

Tooling:

Accept

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Draw

Number

Date:

Draw

Rev.

Plan

Code

Run

Accept

Qty

Start

Stop

Setup Start

Stop

Reject

Qty



Number Stamp

Insp.

Reject

Sequence ID/

**Work Center ID** 

130

**Ouality Control** 

**Operation** Description

QC8- Inspect parts - second check

Memo

0.00

0.00

Small Fab

Small Fab

140

Small Fab

Memo

Tumble Deburr any rough edges after tumbling

m. L 09/07/27

150

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

BR 09-07-27

0.00

Page 2

# **Dart Aerospace Ltd**

W/O:			WC	RK ORDER CHANG	ES			-	
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		DAD #-	Fault Cata	,	NOD: Var	N- DO		<b>D</b> - <b>L</b> -	
i ait ito		PAR #:							
NCR:				ER NON-CONFORMA				Dutc	
DATE	0755	Description of NC		Corrective Action Section B			ation	Approval	0
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date		Verification Appl Section C Chief		Approval QC Inspector
							···	, , , , , , , , , , , , , , , , , , ,	
•									
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#### Work Order ID 50227

F

July 14, 2009 10:26:01 AM

Page 3

Item ID:

D2274

Accept

Accept

Qty

Setup Start

Stop



**Revision ID:** 

Radius Block Item Name:

Required Date: 7/15/09

**Start Date:** 

7/15/09

QC:

**Start Qty: 148.00** 

Req'd Qty: 148.00



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Insp.

Stamp

Sequence ID/ **Work Center ID** 

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Date: \_\_\_\_\_\_

Set Up/ **Run Hours** 

0.00

0.00

09-07-28

Draw

Rev.

Plan

Code

Qty

Reject

Reject

Number

170

Packaging

Packaging

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location.

Memo

0.00

0.00

og 67/29

# **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			· · · · · · · · · · · · · · · · · · ·						
<del>-</del>									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)		1/4	
DATE	STEP	Description of NC	Corrective Action Section B			Verifi	cation Approve	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
							_		
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July 14, 2009 10:26:01 AM

Work Order ID: 50227

Parent Item:

D2274RevF

Parent Item Name: Radius Block

Comments:



**Start Date: 7/15/09** 

Required Date: 7/15/09

**Start Qty: 148.00** 

Required Qty: 148.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issue	_ 51	tatus
M6061T6B00750X00.1		Purchased	No			100	f	106.2400	14.2703	<del></del>			

6061-T6 Bar .750 x .125

Warehouse	Loc Oty	Loc Code	
<b>Location</b>			
Main Warehouse			
MAT	106.24		
104725	7.52		
105061	11.4		
109760	16.25		
110591	71.07	110.591	_15.

<b>Dart</b>	Aer	OSI	nac	e I	td
-416	, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	~~	2	<b>-</b>	

W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCF	R: Yes	No <b>DQ</b>	A:	Date:	
	Re	esolution:	Disposition	on:	QA:	N/C CIO	sed:		Date: _	<del></del>
NCR:	·	,	WORK ORD	ER NON-CONFORM	IANCE	(NCR	)			
DATE	STEP	Description of NC	Corrective Action Section B				Verific	cation	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
	_									
		•								
-							74			
	1 1						1		I	

DART AEROSPACE LTD	Work Order:	50ZZ7
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	0.260	/			
0.750	+/-0.010	.747				
0.375	+/-0.010	.375				
0.125	+/-0.010	.123				
0.750	+/-0.010	.746				
0.063	+/-0.010	-0/e/				
	ļ					
4			ļ			

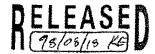
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 04/07/20	Date: 09/0	1/23 Date:	N/A

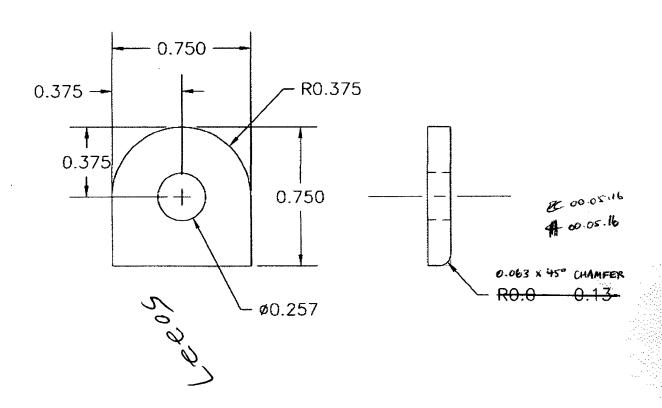
Rev	Date	Change	Revised by	Approved
Α	03.10.07	New Issue	KJ/RF	





DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	SPAV SPAN	APPROVED	DRAWING NO.	REV. F
		14	D2274 SHEET 1	OF 1
DATE	DATE		TITLE	SCALE
98.0	98.08.11		RADIUS BLOCK	2:1
Α		94.09.29	NEW ISSUE	
С		95.07.12	RADIUS ENDS	
D		97.03.24	ADD MATERIAL SPECIFICATION	, , , ,
Ε		97.12.12	ADD FINISH & TOLERANCE QSI	
F		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125	





MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED